

Date: Monday, 3/26/2007 3:23:16 PM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services	Drawing Name	LUG
Job Number	31485A		
Estimate Number	10839		
P.O. Number	N/A	Part Number	D22491
This Issue	3/26/2007	Drawing Number	D2249 REV. E
Prsht Rev.	NC	Project Number	N/A
First Issue	N/A	Drawing Revision	E
Previous Run	31067	Material	N/A
Written By		Due Date	4/10/2007
Checked & Approved By	<u>01.03.27</u>	Qty:	4
Comment	Est: D 05.02.04 Added Step 9 KJ/RF Est Rev:E Now on Waterjet 07-03-08 JLM	Um:	Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:
1.0	M304S16GA	304/316 .063 Sheet
		 Comment: Qty.: 0.0903 sf(s)/Unit Total : 0.3612 sf(s) 304/316 .063 Sheet Batch: M103961
2.0	WATER JET	FLOW WATER JET
		 Comment: FLOW WATER JET 1-Cut as per Dwg D2249 Dwg Rev: E Prog Rev: E
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
		 Comment: INSPECT PARTS AS THEY COME OFF MACHINE
4.0	QC8	SECOND CHECK
		 Comment: SECOND CHECK
5.0	PACKAGING 1	PACKAGING RESOURCE #1
		 Comment: PACKAGING RESOURCE #1 Identify and Stock Location: 65

W/O:		WORK ORDER CHANGES				
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 07/06/29
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 3/26/2007 3:23:16 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LUG

Job Number: 31485A

Part Number: D22491

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

3/26/07

Job Completion



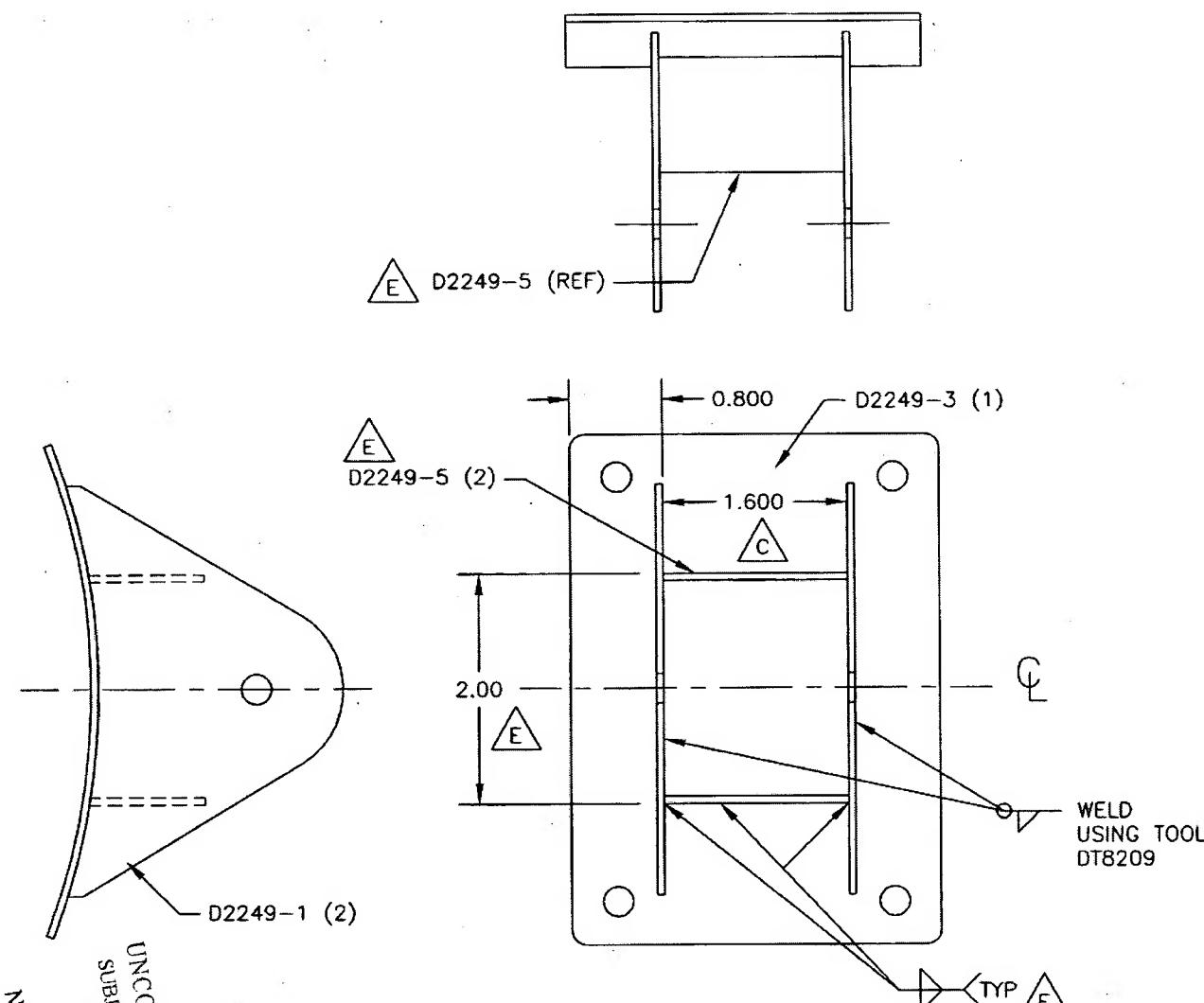
3/26/07
07.06.28

W/O:		WORK ORDER CHANGES				
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



MATERIAL: AISI 304/316 SS, 0.063 THICK
 WELD PER DART QSI 004
 FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
 ALL DIMENSIONS ARE IN INCHES
 TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE SPECIFIED

SHOP COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 31482A

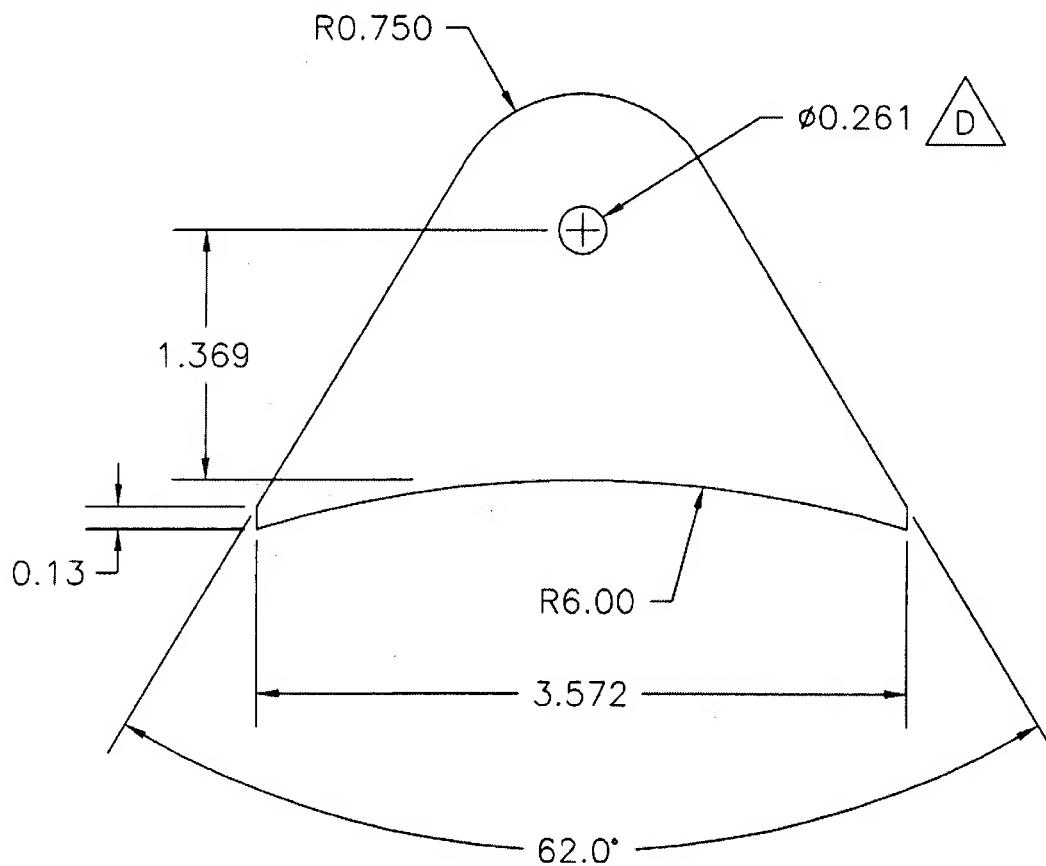
RELEASED

99.10.12
 KCE

DESIGN	DRAWN BY	DART AEROSPACE LTD
<i>KE</i>	<i>RF</i>	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
<i>KE</i>	<i>W</i>	D2249
DATE		REV. E
99.09.20	TITLE	SHEET 1 OF 4
	FITTING	NTS
A	94.06.20	NEW ISSUE
B	95.11.30	DIMENSION CHANGE
C	95.12.14	DIMENSION CHANGE
D	98.04.30	$\phi 0.261$ WAS $\phi 0.257$ (TSR A179) REMOVED DUPLICATE DIMENSIONS
E	99.09.20	ADDED GUSSET

DART

DESIGN <i>KE</i>	DRAWN BY <i>RF</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>KE</i>	APPROVED <i>RF</i>	DRAWING NO. D2249
DATE 99.09.20	TITLE FITTING	REV. E SHEET 2 OF 4 SCALE 1:1

RELEASED
99.10.12 KED2249-1 LUG

MATERIAL: AISI 304/316 SS 0.063 THICK

ALL DIMENSIONS ARE IN INCHES

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

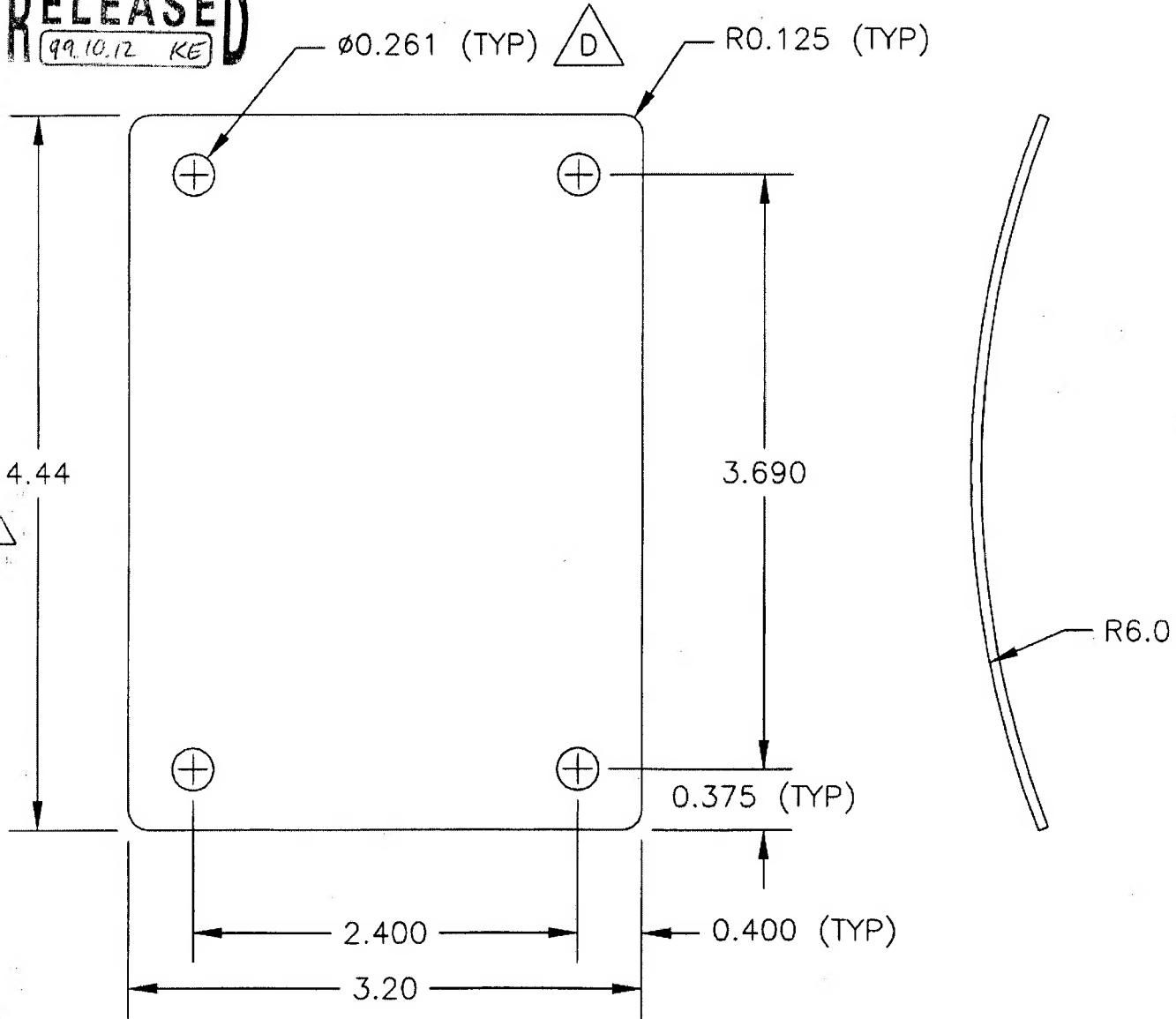
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WITHOUT NOTICE
WORK ORDER
NO. 31485A



DESIGN <i>RE</i>	DRAWN BY <i>RF</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>RE</i>	APPROVED <i>TM</i>	DRAWING NO. D2249	REV. E SHEET 3 OF 4
DATE 99.09.20	TITLE FITTING		SCALE 1:1

RELEASED
99.10.12 KE

99.10.12 KE



FLAT PATTERN

D2249-3 BASE PLATE

MATERIAL: AISI 304/316 SS 0.063 THICK

ALL DIMENSIONS ARE IN INCHES

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

BEND DETAIL
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WITHOUT NOTICE
IN ORDER - A

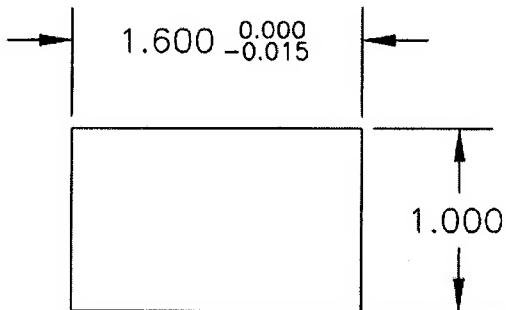
NO. 3148

DART

DESIGN <i>KE</i>	DRAWN BY <i>RF</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>KE</i>	APPROVED <i>W</i>	DRAWING NO. D2249
DATE 99.09.20	TITLE FITTING	REV. E SHEET 4 OF 4 SCALE 1:1

RELEASED

99.10.12 KE

D2249-5 GUSSET

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UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *31485A*

MATERIAL: AISI 304/316 SS 0.063 THICK
ALL DIMENSIONS ARE IN INCHES
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

DART AEROSPACE LTD

Work Order: 31485A

Description: LUG

Part Number: D2249-1

Inspection Dwg: D2249 Rev: E

Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

 First Article Prototype

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A $\phi 0.261$	$+\ 0.006$ $-\ 0.001$	$\phi 0.261$	✓		Very	
B 1.369	$+\ -0.010$	1.374	✓		Very	
C 3.572	$+\ -0.010$	3.580	✓		Very	
D 0.13	$+\ -0.020$	0.14	✓		height gauge	
E 0.063	$+\ -0.010$	0.088	✓		vern	
F						
G						
H						
I						
J						
K						
L						
M						
N						
O						
P						
Q						
R						
S						
T						
U						
V						
W						
X						
Y						

Measured by: SAD
Date: 03/04/14

Audited by: 
Date: 07/04/16

Prototype Approval: N/A
Date: N/A

Rev	Date	Change	Revised by	Approved
		New Issue	KJ/RF	